

Work Order ID 79388

January-25-12 11:51:46 AM

\*79388\*

Page 1

Item ID: D212-664-207

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Item Name: Crosstube Low Standard Aft

Stop

\*NS2\*

Start Date: 25/01/2012 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 08/02/2012 Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Approvals: Process Plan: M.L.J

Date: 12/01/25 Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr	
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D212-664-247	Rev B (DEO)	
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100

0.00

\*100\*

DOCUMENT CONTROL

DC

0.00

Document Control

Memo

Photocopy bluefile and create labels as per PPP D212-664-207 CHG002

5/7/03/02

M.L.J 12-3-2  
①

110

Pick Kit

0.00

\*110\*

Packaging

0.00

Packaging

Memo

0.00

MO/RM

12/2/15

120

0.00

\*120\*

BENDING MACHINE - CROSSTUBES

CNC Bend 2

Memo

0.00

CNC Alpha 160 Bender

Bend tube as per Dwg D212-664-247 using CNC bender program

and Folio

FT

MO/RM

12/2/16

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

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Cust Item ID:

Required Date: 08/02/2012 Req'd Qty: 1.00 \*1\*

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Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:	Stop		*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  <b>*130*</b> QC Quality Control	QC15- Crosstube Dimensional Check  Memo	0.00  0.00	812/02/17						

140  
  
**\*140\***  
Crosstubes

Memo 0.00  
1-Drill Rivet holes as per Dwg D212-664-247 using DT8972.\*\*\*Use T-Pin\*\*\*  
2-Drill pilot holes in tube as per Dwg D212-664-247 using DT8550 and DT8551  
3-Ream hole to finish size in tube as per Dwg D212-664-247  
4-Deburr & Inspect for surface damage. Repair damage within limits as per  
Dwg D212-664-247

5-Scribe part # and batch # using vibrating stylus as per Dwg D212-664-  
247

3 TW  
4 TW  
5 TW

12-2-21

12-2-22

12-2-21

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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\*NS2\*

Start Date: 25/01/2012 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 08/02/2012 Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:	Stop		*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 <b>*150*</b> HandFXtube	Crosstubes Chemical Conversion	0.00							
Hand Finishing Crosstubes	Memo	0.00							
	Chemical Conversion Coat Tube & Cuffs								
160 <b>*160*</b> QC Quality Control	QC3- Inspect Part Finish	0.00							
	Memo	0.00							
170 <b>*170*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O	0.00							
	Memo	0.00							

SRM 12-2-23

11 01 23 (1)

11 01 23 (1)

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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\*1\*

Cust Item ID:

Required Date: 08/02/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:	Stop		*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210		0.00							
*210*	Crosstubes								
Crosstubes	Memo	0.00							
Crosstubes	1-Rivet and assemble Cuffs with T-Pin in the through bolt holes as per Dwg D212-664-247. with Sika flex in Between tube & Cuff								
	A/R SIKAFLEX -241-291 BATCH: 11999								

215	QC5- Inspect part completeness to step on W/O	0.00
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12-02-28

*215*		
QC	Memo	0.00
Quality Control	***Inspect cuff with T-Pin***	

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Stop

\*NS2\*

Start Date: 25/01/2012 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 08/02/2012 Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:	Stop		*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

240

\*240\*

Crosstubes

Crosstubes

0.00

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Crosstubes

Memo

0.00

AS 12-2-29

Crosstubes

I- Assemble as per Dwg D212-664-247

1-Abrade mating surfaces of support and crosstube with 400 grit sandpaper,  
clean the area with 4105S wash 'n' wipe

2-Install supports with Proseal 890 per DSI9563 and QSI 015  
A/R Proseal 890 Batch: 12C072

3- Torque bolts as per dwg

250

QC5- Inspect part completeness to step on W/O

0.00

\*250\*

QC

Quality Control

Memo

0.00

5.26.101

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Item Name: Crosstube Low Standard Aft

Stop

\*NS2\*

Start Date: 25/01/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 08/02/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
					Stop		*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
255 <b>*255*</b> Packaging Packaging	Pick Kit  Memo	0.00							12/31/12

260 <b>*260*</b> QC Quality Control	QC4- 100% Inspect kits for completeness  Memo	0.00 0.00	5.2/03/02						
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270 <b>*270*</b> Packaging Packaging	Packaging  Memo Identify and pack for shipping as per PPP D212-664-207	0.00 0.00							12/3/12
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Rev.C 1-6-02

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID 79388

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Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Item Name: Crosstube Low Standard Aft

Stop

\*NS2\*

Start Date: 25/01/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 08/02/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start

\*NR1\*

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

280

QC21- Final Inspection - Work Order Release

\*280\*

QC

Quality Control

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

0.00

12/3/16

SD

Memo

0.00

WME

12-03-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

January-25-12 11:51:50 AM

Page 1

Work Order ID: 79388

\*79388\*  
\*D212-664-207\*

Parent Item: D212-664-207

Parent Item Name: Crosstube Low Standard Aft

Start Date: 25/01/2012

Required Date: 08/02/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:A New Issue 07.09.12 EC verified by: JLM  
 IPP Rev:B ECN 1100p 08-01-11 DD verified by: EC  
 IPP Rev:C ECN 1121 08-02-25 DD verified by: eC  
 IPP Rev: D QC5 replaced by QC15 at step 5 KJ Verified by: ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D212-664- 207TRNRevA		Manufactured	No		78422	110	Each	0.0000	1	1	1	mof	12/2/15

\*D212-664-207TRNRevA\*

Crosstube Turning Detail

D3660-1 Manufactured No

\*D3660-1\*

CUFF

CR3212-4-06

\*CR3212-4-06\*

CHERRY RIVET

Location	Loc Qty	Loc Code
----------	---------	----------

ST482	4	
53501	1	
76260	3	

	44	1	12-2-21
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	44	1	12-2-21
--	----	---	---------

	44	1	12-2-21
--	----	---	---------

Location	Loc Qty	Loc Code
----------	---------	----------

ST331	286	
112492	18	
112794	8	

119717	203	
120187	57	

	44	
--	----	--

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
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**Picklist Print**

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**Work Order ID:** 79388**\*79388\*****Parent Item:** D212-664-207**\*D212-664-207\*****Parent Item Name:** Crosstube Low Standard Aft**Start Date:** 25/01/2012**Required Date:** 08/02/2012**Start Qty:** 1.00**Required Qty:** 1.00

D3595-063-530

Manufactured No

240 Each

79.0000

4 4

**\*\***

Af 12-2-29

**\*D3595-063-530\***

RUBBER CUSHION

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT052	79	
63407	6	
67185	6	
70067	18	
72745	8	
75783	41	

D2940-1

Manufactured No

240 Each

13.0000

2

**\*\***

Af 12-2-29

**\*D2940-1\***

Support

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG	3	
76729	3	
LG052	10	
76729	10	

MS21920-28

Purchased No

240 Each

59.0000

4

**\*\***

Af 12-2-29

**\*MS21920-28\***

Clamp(per MIL-DTL-8783C)

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	5	
105884	5	
LG050	54	
116839	2	
118713	4	
119285	1	
119920	17	
120054	30	

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item: D212-664-207

\*D212-664-207\*

Parent Item Name: Crosstube Low Standard Aft

Start Date: 25/01/2012

Required Date: 08/02/2012

Start Qty: 1.00

Required Qty: 1.00

D3428-1

Manufactured No

255

Each

25.0000

1

\*\*

1  
ESB

\*D3428-1\*

Placard

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST042	25	
76508	5	
78933	20	

MS21042L6

Purchased No

255

Each

1,202.000

6

\*\*

1  
6  
SP

\*MS210421 6\*

Nut

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST300	1202	
117677	25	
118384	3	
118927	48	
119075	926	
120308	200	

AN960JD616

NAS1149D0663J Purchased

No

255

Each

0.0000

18

\*\*

18  
m 119075 5 SP

\*AN960.JD616\*

Washer

AN6-40A

Purchased No

255

Each

124.0000

4

\*\*

4  
123110 SP

\*AN6-40A\*

Bolt

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST342	124	
119749	24	
120187	100	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**\*79388\***

Parent Item: D212-664-207

**\*D212-664-207\***

Parent Item Name: Crosstube Low Standard Aft

**Start Date:** 25/01/2012**Required Date:** 08/02/2012**Start Qty:** 1.00**Required Qty:** 1.00

AN6-41A

Purchased

No

255

Each

45.0000

2

2

\*\*

12315P 5P

**\*AN6-41A\***

Bolt

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST342	45	
119749	20	
<u>120187</u>	25	<u>2</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

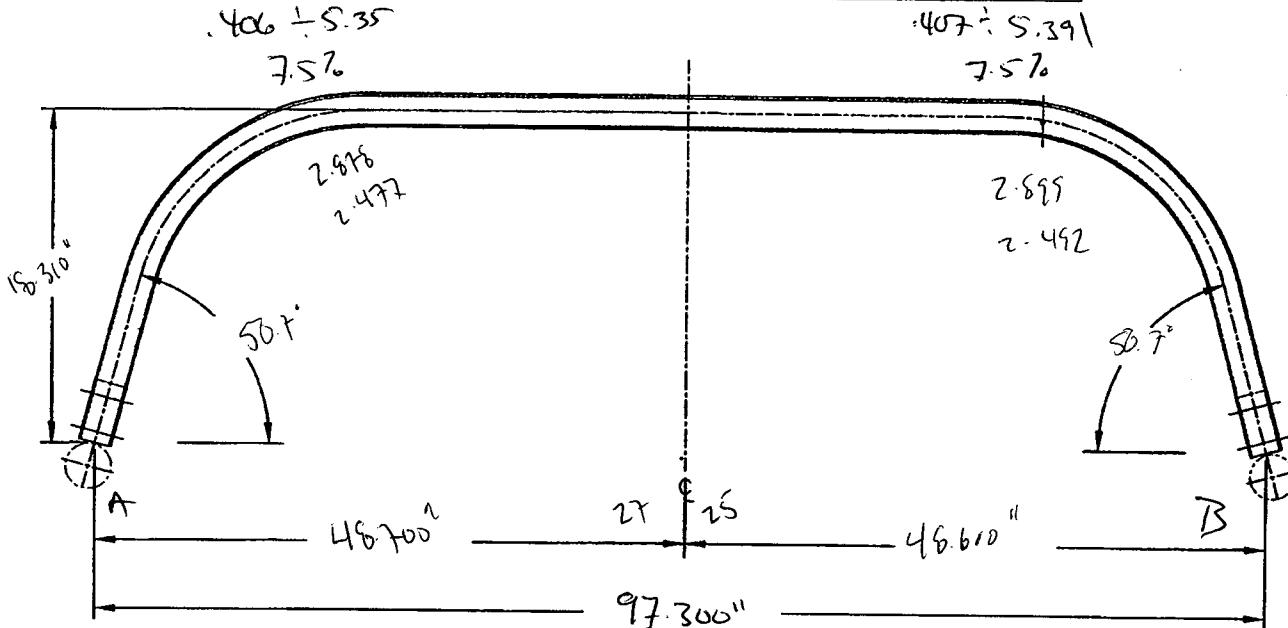
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	79388
Description: Crosstube Low Aft (205/212)	Part Number:	D212-664-207
Inspection Dwg: D212-664-247	Rev: B	Page 1 of 1

Required Dimension	Min	Max
Height	18.16	18.42
1/2 Span	48.55	48.81
Angle	49	52
Total Span	97.1	97.62



Comments
Size A = 7.5% crush @ 27 Passer
Size B = 7.5% crush @ 25 Passer
* See note # 10.

QC15 Inspection	<i>8</i>
Date	12/02/17

Rev	Date	Change	Revised by	Approved
A	08.02.29	New Issue	KJ/JM	<i>KJ</i>
B	10.04.01	Dwg Rev updated	KJ	<i>J</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

B

Item	Qty -247	Qty -247B	Part Number	Description
1	X		D212-664-247	CROSSTUBE ASSEMBLY (205/212 LOW AFT)
2		X	D212-664-247B	CROSSTUBE ASSEMBLY (214 LOW AFT)
3	1	1	D6008-132	CROSSTUBE
4	2	2	D2940-1	SUPPORT
5	4	4	D3595-063-530	RUBBER CUSHION
6	2	2	D3660-1	CUFF
7	4	4	MS21920-28	CLAMP (OR MS21920-30)
8	44	44	CR3212-4-06	RIVET (OR M7885/3-4-06)
9	A/R	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)
10	A/R	A/R	SIKAFLEX-241/-291	SEALANT (OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT)

## GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6008-132  
FINISHED LENGTH = 128.268±0.020 (BEFORE BENDING/TRIMMING)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D212-664-XXX" AND BATCH NUMBER ON INSIDE OF CUDD USING VIBRATING STYLUS.
- 7) WEIGHT: D212-664-247 = 36.6 lbs (PER IIN-D212-664)  
D212-664-247B = 36.6 lbs (PER IIN-D212-664)
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) WHEN MACHINING TAPER, RUN CUTTER OFF PART. BLEND OUT EDGE LONGITUDINALLY. TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D. EXCEPT UP TO 10% IS ALLOWED IN AREA NOTED.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2940-1 SUPPORT USING 0.03" TO 0.05" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2940-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-28 CLAMPS (OR -30) WITH D3595-063-530 RUBBER CUSHIONS TO SECURE THE D2940-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE OF CROSSTUBE SUPPORT.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED OUT AFTER TORQUING.
- 16) INSTALL D3660-1 CUFF AFTER CHEMICAL CONVERSION COAT BUT BEFORE PAINT. WITH A LAYER OF SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT BETWEEN CUDD AND CROSSTUBE. SEAL EDGE OF CUDD TO ENSURE NO GAPS.
- 17) TOUCH-UP HOLES WITH CHEMICAL CONVERSION COAT.

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 79388 H.C.J  
12/01/25

DETACHED

I-614

11.07.07

UNDER REVIEW

OP/AB/13

RELEASED  
2009-10-29

NP

B	REVISE GENERAL NOTES/PART LIST; UPDATE TO CURRENT STANDARDS: ADD -247B (ZN C4-2, DS-2)			RF	09.09.30
A	NEW ISSUE			CP	07.07.07
REV.	DESCRIPTION			BY	DATE
DESIGN	90	DART AEROSPACE LTD			
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA			
CHECKED	90	DRAWING NO.	REV. B		
MFG. APPR.	DS	D212-664-247	SHEET 1 OF 4		
APPROVED	100	TITLE	SCALE		
DE APPR.	100	CROSSTUBE (205/212 LOW AFT)	NTS		
DATE	09.09.30	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE LTD. IT IS FOR INTERNAL USE ONLY AND IS PROHIBITED THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

8 7 6 5 4 3 2 1

D

C

B

A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

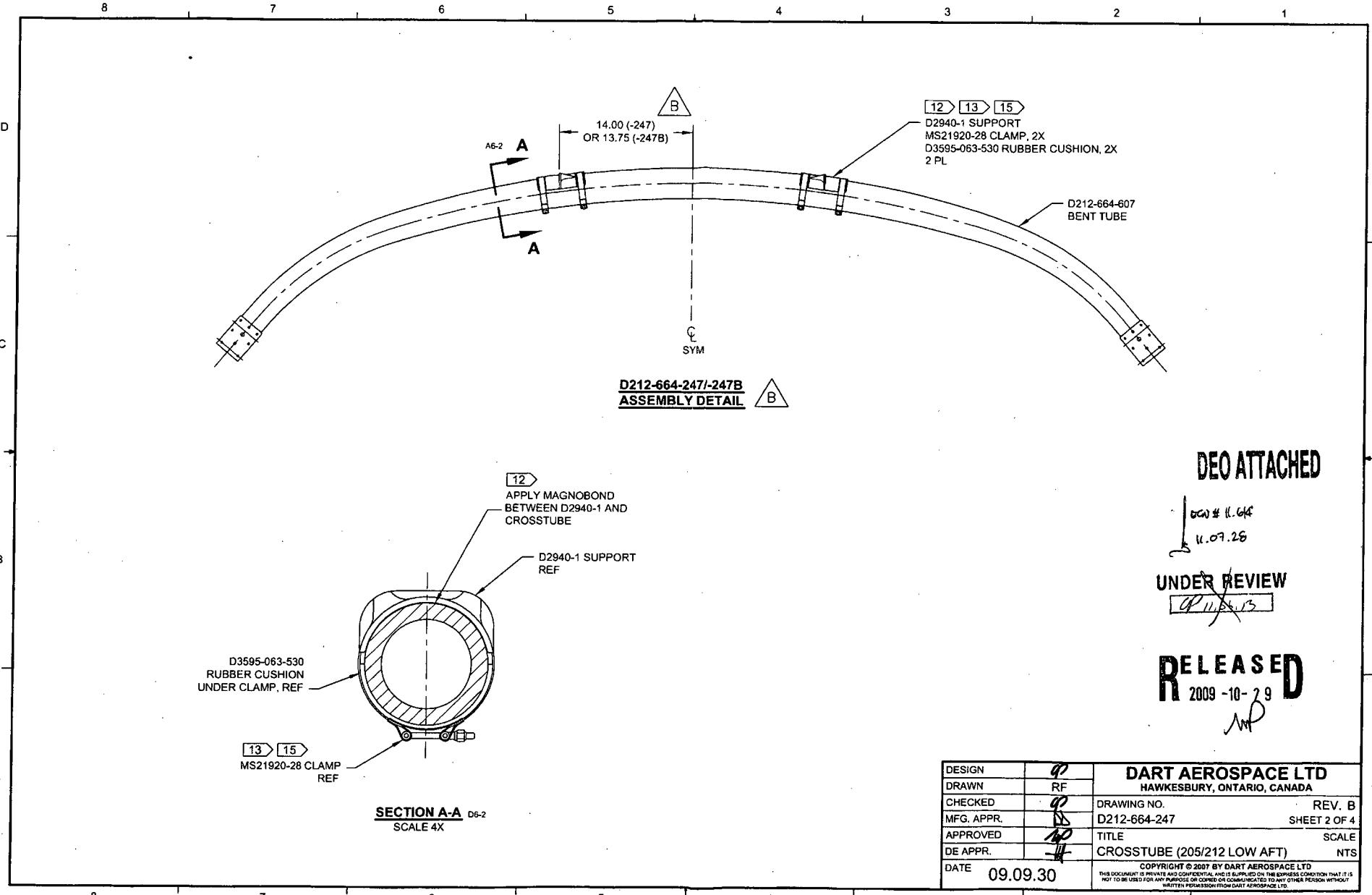
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

79388



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

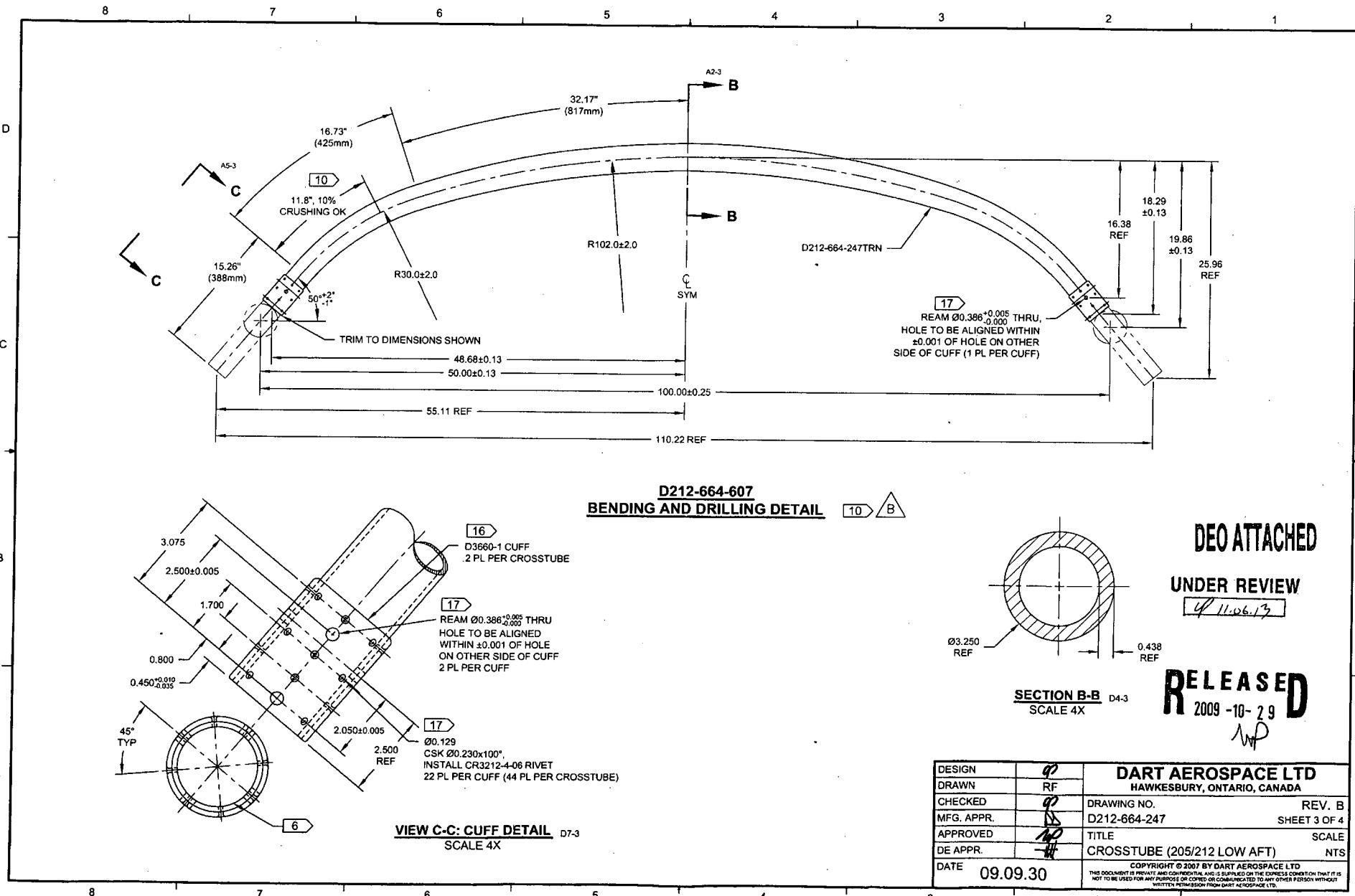
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

79388



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries





W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

79388

DRAWING NO. D212-664-247	TITLE CROSSTUBE ASS'Y (205 LOW AFT)	REV. B	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D212-664-247-B-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>JP</i>	CHECKED <i>ASS</i>	MFG. APPR. <i>AS</i>	APPROVED <i>WD</i>	DE APPR. <i>W</i>		
DATE 11.07.15	DATE 11.07.20	DATE 11.07.21	DATE 11.07.21	DATE 11.07.21	DATE 11.07.21	

**PURPOSE:**

REPLACE MAGNOBOND WITH PROSEAL.

**CHANGE:**

IS:

Item	Qty -247	Qty -247B	Part Number	Description
9	A/R	A/R	PROSEAL 890 B-2	SEALANT, AMS-S-8802 CLASS B-2

**WAS:**

9	A/R	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)
---	-----	-----	----------------	---

NOTE 12 &amp; 15, SHEET 1 IS AMENDED AS FOLLOWS:

IS:

12) TO INSTALL D2940-1 SUPPORT: ABRADE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.04" TO 0.07" THICK LAYER OF PROSEAL 890 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.

15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.

**WAS:**

12) INSTALL D2940-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2940-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.

15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

RELEASED  
2011-07-28  
*WD*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**REFERENCE ONLY**

**DART AEROSPACE LTD.**

**IIN-D212-664**

Page 23 of 25

**5.2 STANDARD GEAR CROSSTUBES**

Item	-107	-207	-209	Part Number	Description
	X			D212-664-107	CROSSTUBE INSTALLATION, 204/205/210/212/214/412, UH-1H, UH-1A/B/E/F/L/P, TH-1F/L, HH-1K STANDARD FWD
		X		D212-664-207	CROSSTUBE INSTALLATION, 204/205/210/212/214, UH-1H, UH-1A/B/E/F/L/P, TH-1F/L, HH-1K STANDARD AFT
			X	D412-664-209	CROSSTUBE INSTALLATION, 412 STANDARD AFT
6	1			D212-664-147	CROSSTUBE ASSEMBLY, 204/205/210/212/214/412, UH-1H, UH-1A/B/E/F/L/P, TH-1F/L, HH-1K STANDARD FWD
7		1		D212-664-247	CROSSTUBE ASSEMBLY, 204/205/210/212/214, UH-1H, UH-1A/B/E/F/L/P, TH-1F/L, HH-1K STANDARD AFT
8			1	D412-664-249	CROSSTUBE ASSEMBLY, 412 STANDARD AFT
10	2			* D2893-1	SUPPORT
11	4			* D3595-063-450	RUBBER CUSHION
12	4			* MS21920-25	CLAMP (OR MS21042-26)
13	4			AN6-35A	BOLT
14	4			AN6-36A	BOLT
15	6			MS21042L6	NUT (OR MS21042-6)
16	18			AN960JD616	WASHER
20		2		* D2940-1	SUPPORT
21		4		* D3595-063-530	RUBBER CUSHION
22		4		* MS21920-28	CLAMP (OR MS21042-30)
23		4		AN6-40A	BOLT
24		2		AN6-41A	BOLT
25		/ 6		MS21042L6	NUT (OR MS21042-6)
26		18		AN960JD616	WASHER
30			1	* D2896-1	SUPPORT
32			2	* D3595-063-570	RUBBER CUSHION
33			4	* MS21920-28	CLAMP
34			2	* MS21920-30	CLAMP (OR MS21042-32)
35			4	AN6-40A	BOLT
36			2	AN6-41A	BOLT
37			6	MS21042L6	NUT (OR MS21042-6)
38			18	AN960JD616	WASHER
39			2	* D3189-1	CHAFING SHIELD
45	2			* D3659-1	CUFF
46		2	2	* D3660-1	CUFF
47	44	44		* CR3212-4-06	RIVET (M7885/3-4-06)
48			44	* CR3212-4-07	RIVET (M7885/3-4-07)
50	1	/ 1		D3428-1	PLACARD

\*REFERENCE ONLY. PARTS ARE INCLUDED IN D212-664-147/247 OR D412-664-249 ASSEMBLIES ABOVE  
NOTE: KITS INCLUDE EXTRA HARDWARE FOR COMPATIBILITY WITH BOTH DART AND BELL/AAI  
SKIDTUBES.

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Revision: **G**  
Date: 11.08.30



# LIQUID PENETRANT TEST REPORT

P- 14907

CLIENT Dart Aerospace DATE FEB 27/2012  
 ATTENTION LINDA TIME AM  PM   
 ADDRESS 1270 ABERDEEN ST. ACUREN JOB NO. 185-12-00053  
 WORK LOCATION SALE  
 PROJECT F.P.I. on cross tubes ACCEPTANCE STD. ASME 1417/PSI-638 REV./DATE 2003  
 ITEM(S) EXAMINED (8) cross tubes

JOB DESCRIPTION PROCEDURE NO. LT 002 REV./DATE 2008 TECHNIQUE NO. LT 002 REV./DATE 2003  
 PART NO. SEE RESULTS MATERIAL AluminuM THICKNESS Various  
 SCOPE A WET FLUORESCENT LIQUID PENETRANT INSPECTOR WAS  
APPLIED AND WASHED ON THE EXTERNAL SURFACE.

TEST DETAILS

METHOD <input checked="" type="checkbox"/> FLUORESCENT <input type="checkbox"/> VISIBLE	<input type="checkbox"/> WATER WASH <input checked="" type="checkbox"/> SOLVENT REMOVABLE <input type="checkbox"/> POST EMULSIFIED
FAMILY BRAND <u>Wet fluorescent</u>	BLACK LIGHT S/N <u>16459</u> <input type="checkbox"/> OUTPUT > 1000 $\mu$ W/CM <sup>2</sup> <input type="checkbox"/> AMBIENT < 2 fc
PENETRANT <u>WATER</u> MINIMUM Dwell TIME <u>45:30</u> MIN.	LIGHTING EQUIP. <input type="checkbox"/> FLASHLIGHT <input type="checkbox"/> TROUBLELIGHT <input type="checkbox"/> OUT <u>1000 fc @ SURFACE</u>
PENETRANT REMOVER <u>WATER</u> MINIMUM DRY TIME <u>&gt;10</u> MIN.	OTHER <u>LA300</u>
DEVELOPER <u>Water</u> MINIMUM Dwell TIME <u>10</u> MIN.	LIGHT METER S/N <u>1098866</u> CAL DUE DATE <u>July 27/2012</u>
DEVELOPER TYPE <input type="checkbox"/> NON AQUEOUS <input checked="" type="checkbox"/> AQUEOUS <input type="checkbox"/> DRY	

TEST SURFACE

SURFACE CONDITION <input type="checkbox"/> AS GROUND <input checked="" type="checkbox"/> AS WELDED <input type="checkbox"/> MACHINED <input type="checkbox"/> SHOT BLASTED <input checked="" type="checkbox"/> CLEAN BARE METAL
SURFACE TEMPERATURE <input type="checkbox"/> < -4°C/ 20°F <input type="checkbox"/> -4°C/ 20°F TO 10°C/50°F <input checked="" type="checkbox"/> 10°C/50°F TO 52°C/125°F <input type="checkbox"/> > 52°C/125°F

RESULTS-  METRIC  IMPERIAL

<u>Cross tube W.O. 75948</u>	<u>Cross tube W.O. 75978</u>
<u>Cross tube W.O. 79368</u>	<u>Cross tube W.O. 79387</u>
<u>Cross tube W.O. 80135</u>	<u>Cross tube W.O. 80134</u>
<u>Cross tube W.O. 77538</u>	<u>Cross tube W.O. 77537</u>

→ Red Indication

8/2/2012

## Scope of Services

The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

## Standard of Care

In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

## SIGNATURES

CLIENT REPRESENTATIVE <u>Andrew Sheldon</u> PRINT <u>Sheldon</u> SIGNATURE <u>Sheldon</u> DTR # <u>E 63814</u>
TECHNICIAN (SIGNATURE): <u>Andrew Sheldon</u>
NAME (PRINT): <u>Andrew Sheldon</u> 1 <sup>ST</sup> TECHNICIAN CGSB LEVEL <u>E</u> SNT LEVEL <u>E</u> 2 <sup>ND</sup> TECHNICIAN CGSB LEVEL _____ SNT LEVEL _____
CGSB REG. NO. <u>6606</u> CGSB REG. NO. _____

REPORT  
REVIEWED BY:

NAME ED INITIALS ED